Victory™ Shoulder Mill 17™

ADVANCES 2017

Metric

WIDIA™

WIDIA™ Victory™ Shoulder Mill 17™ • **VSM17™**

WIDIA™ Victory Shoulder Mill 17 is a high-performance, versatile, robust, 90° square shoulder milling platform. VSM17 is designed for versatility, low horsepower consumption, and easy cutting action. Cutters can be used for shoulder milling, profiling, face milling, slotting, ramping, helical interpolation, and circular interpolation milling applications. Inserts are specially designed with innovative geometries and features like variable rake angles, negative T-land, small hone, and the latest Victory grades enhancing tool performance and versatility.

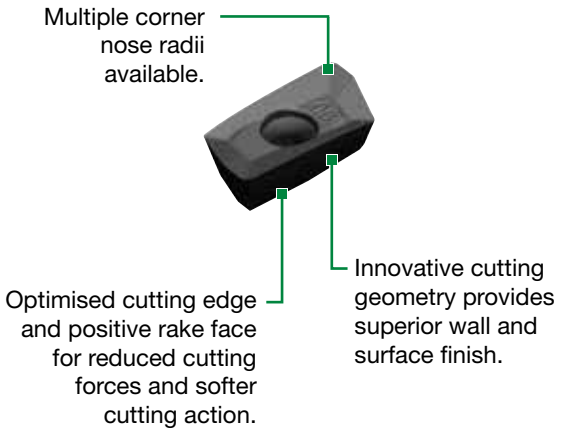
Take advantage of the high-performance, advanced carbide substrates, coatings, and surface treatment technologies of the available 7 Victory grades, 4 geometries, and a broad-range cutter body product portfolio. This platform works with multiple material types and applications.

- Up to 16,33mm (.65") depth-of-cut capabilities.
- State-of-the-art step down capability.
- Screw-on, end mill, and shell mill cutters with effective internal coolant supply.

VSM17

Features
- Insert geometries and grades for all workpiece materials.
- Insert corner radius from 0,4–4mm (.015–.157").
- Max axial depth of cut 16,3mm (0.65").

Benefits
- Achieve true 90° wall finish.
- High performance and longer tool life.
- Latest WIDIA Victory milling grades for all workpiece materials.
- High positive geometry, soft cutting action, reduced cycle times, and low horsepower consumption.
- Stability and reliability.

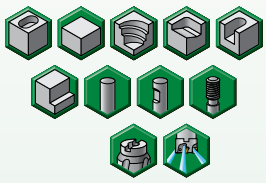


90° Shoulder Mills

VSM17™

Max depth of cut: 16,33mm

Lead angle: 90°
Indexes per insert: 2
Diameter: 25–160mm



Insert Offering

XDPT-MM

Medium to heavy machining.
First choice for general purpose.
Precision pressed to size.

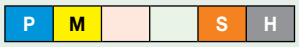
XDPT-MH

First choice for heavy-duty machining.
Steel and cast iron materials.
Precision pressed to size.

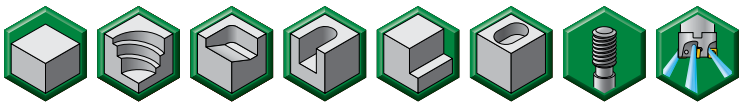
XDCT-ALP

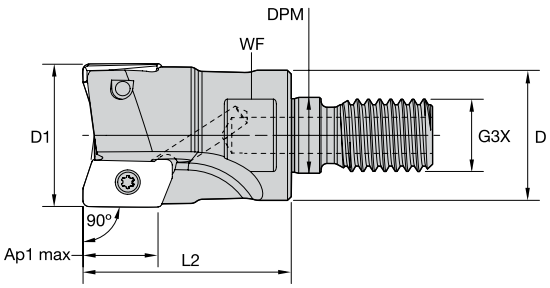
Roughing and finishing
of aluminium alloys.
High precision.
Periphery ground.

XDCT-ML



Light to medium machining.
First choice for stainless steel
and titanium.
Periphery ground.





Screw-On End Mills

order number	catalogue number	D1	D	DPM	G3X	L2	WF	Ap1 max	Z	max ramp angle	coolant supply	max RPM	kg
5988091	**VSM17D025Z02M12XD17**	25	21	12,5	M12	35	17	16,3	2	8.8	Yes	41800	0,08
5988092	**VSM17D032Z03M16XD17**	32	29	17,0	M16	40	24	16,3	3	5.7	Yes	34700	0,17
5988132	**VSM17D32Z02M016XD17**	32	29	17,0	M16	40	24	16,3	2	5.7	Yes	34700	0,18
5988093	**VSM17D040Z04M16XD17**	40	29	17,0	M16	40	24	16,2	4	4.0	Yes	29800	0,20
5988131	**VSM17D40Z03M016XD17**	40	29	17,0	M16	40	24	16,2	3	4.0	Yes	29800	0,20

Spare Parts

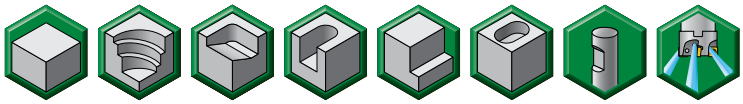
insert screw

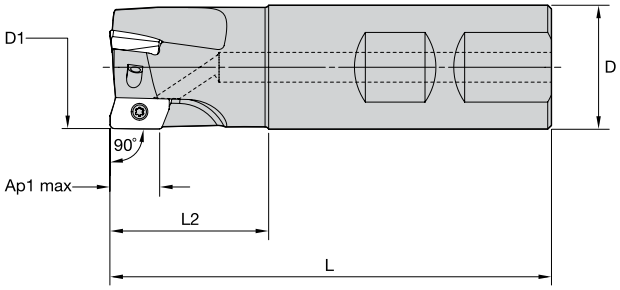
Nm

wrench

insert screw	Nm	wrench
191.725	3,5	**170.025**

NOTE: Standard milling cutters will accept insert nose radii up to 1,6mm without modification.
For tool body modification instructions, see page 14.





Weldon Shanks

order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	coolant supply	max RPM	kg
5988102	**VSM17D025Z02B25XD17**	25	25	90	33	16,3	2	8.8	Yes	41800	0,26
5988136	**VSM17D032Z02B32XD17**	32	32	100	39	16,3	2	5.7	Yes	34700	0,49
5988103	**VSM17D032Z03B32XD17**	32	32	100	39	16,3	3	5.7	Yes	34700	0,48
5988137	**VSM17D040Z03B40XD17**	40	40	110	39	16,2	3	4.0	Yes	29800	0,88
5988104	**VSM17D040Z04B40XD17**	40	40	110	39	16,2	4	4.0	Yes	29800	0,87

Spare Parts

insert screw

191.725

Nm

3,5

wrench

170.025

NOTE: Standard milling cutters will accept insert nose radii up to 1,6mm without modification.
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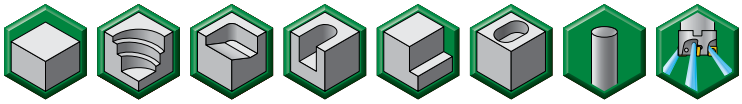
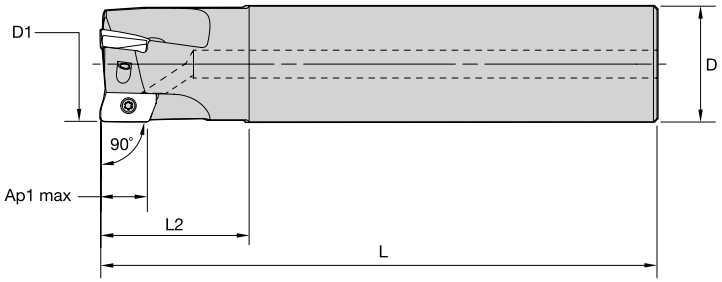




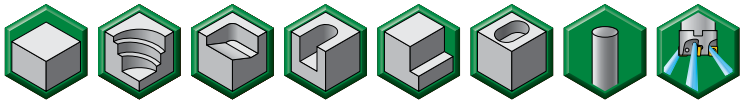
Cylindrical End Mills

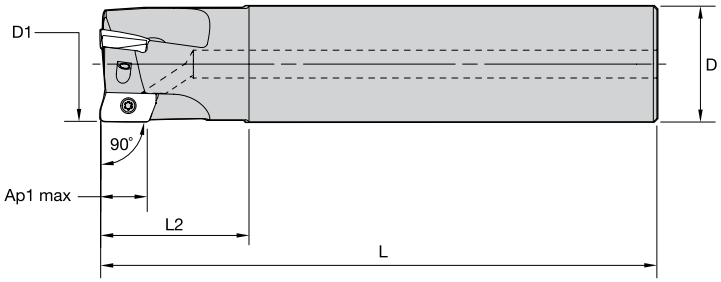
order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	coolant supply	max RPM	kg
5988055	**VSM17D025Z02A25XD17L110**	25	25	110	44	16,3	2	8.8	Yes	41800	0,32
5988056	**VSM17D025Z02A25XD17L170**	25	25	170	44	16,3	2	8.8	Yes	41800	0,54
5988107	**VSM17D032Z02A32XD17L120**	32	32	120	50	16,3	2	5.7	Yes	34700	0,60
5988057	**VSM17D032Z03A32XD17L120**	32	32	120	50	16,3	3	5.7	Yes	34700	0,60
5988109	**VSM17D040Z03A32XD17L130**	40	32	130	50	16,2	3	4.0	Yes	29800	0,77
5988059	**VSM17D040Z04A32XD17L130**	40	32	130	50	16,2	4	4.0	Yes	29800	0,77

Spare Parts

insert screw	Nm	wrench
191.725	3,5	**170.025**

NOTE: Standard milling cutters will accept insert nose radii up to 1,6mm without modification.
For tool body modification instructions, see page 14.





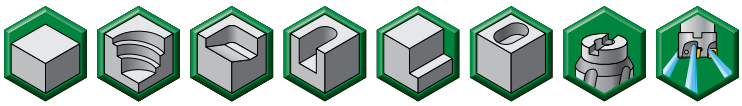
Cylindrical End Mills • Long Shank

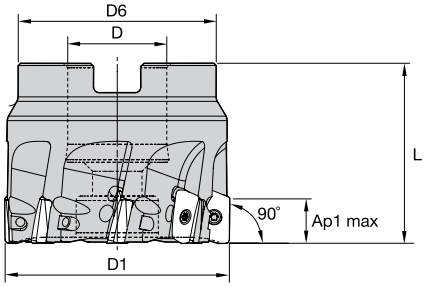
order number	catalogue number	D1	D	L	L2	Ap1 max	Z	max ramp angle	coolant supply	max RPM	kg
5988108	**VSM17D032Z02A32XD17L210**	32	32	210	50	16,3	2	5.7	Yes	34700	1,14
5988058	**VSM17D032Z03A32XD17L210**	32	32	210	50	16,3	3	5.7	Yes	34700	1,13
5988110	**VSM17D040Z03A32XD17L250**	40	32	250	50	16,2	3	4.0	Yes	29800	1,49
5988060	**VSM17D040Z04A32XD17L250**	40	32	250	50	16,2	4	4.0	Yes	29800	1,49

Spare Parts

insert screw	Nm	wrench
191.725	3,5	**170.025**

NOTE: Standard milling cutters will accept insert nose radii up to 1,6mm without modification.
For tool body modification instructions, see page 14.

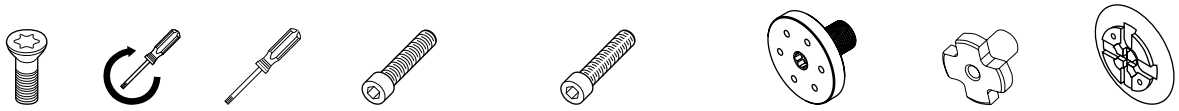




Shell Mills

order number	catalogue number	D1	D	D6	L	Ap1 max	Z	max ramp angle	coolant supply	max RPM	kg
5988094	**VSM17D040Z04S16XD17**	40	16	37	40	16,2	4	4.0	Yes	29800	0,19
5988095	**VSM17D050Z04S22XD17**	50	22	45	40	16,1	4	3.0	Yes	25800	0,28
5988096	**VSM17D050Z05S22XD17**	50	22	45	40	16,1	5	3.0	Yes	25800	0,29
5988134	**VSM17D050Z06S22XD17**	50	22	45	40	16,1	6	3.0	Yes	25800	0,28
5988097	**VSM17D063Z05S22XD17**	63	22	50	40	16,0	5	2.1	Yes	22400	0,45
5988135	**VSM17D063Z06S22XD17**	63	22	50	40	16,0	6	2.1	Yes	22400	0,45
5988098	**VSM17D080Z06S27XD17**	80	27	60	50	15,9	6	1.6	Yes	19500	0,98
5988133	**VSM17D080Z07S27XD17**	80	27	60	50	15,9	7	1.6	Yes	19500	0,96
5988099	**VSM17D100Z08S32XD17**	100	32	80	50	15,8	8	1.2	Yes	17200	1,63
5988100	**VSM17D125Z09S40XD17**	125	40	90	63	15,7	9	0.9	Yes	15200	2,94
5988101	**VSM17D160Z12S40XD17**	160	40	100	63	15,6	12	0.7	Yes	13300	3,66

Spare Parts



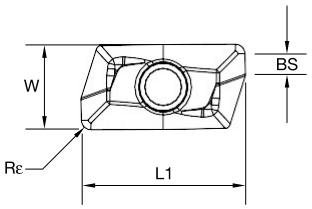
D1	insert screw	Nm	wrench	socket-head cap screw	socket-head cap screw with coolant groove	coolant lock screw assembly	coolant lock screw	coolant cap
40,0	**191.725**	3,5	**170.025**	**MS1294**	**MS1294CG**	–	–	–
50,0	**191.725**	3,5	**170.025**	**MS1234**	**MS1294CG**	–	–	–
50,0	**191.725**	3,5	**170.025**	**MS1234**	**MS1234CG**	–	–	–
63,0	**191.725**	3,5	**170.025**	**MS1234**	**MS1234CG**	–	–	–
80,0	**191.725**	3,5	**170.025**	**MS2038**	**MS2038CG**	–	–	–
100,0	**191.725**	3,5	**170.025**	–	–	**MS2195C**	–	–
125,0	**191.725**	3,5	**170.025**	–	–	**MS2187C**	–	–
160,0	**191.725**	3,5	**170.025**	–	–	–	**12146107000**	**12146111100**

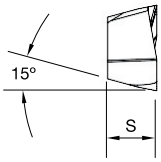
NOTE: Standard milling cutters will accept insert nose radii up to 1,6mm without modification.
For tool body modification instructions, see page 14.

Insert Selection Guide

Material Group	Light Machining		General Purpose		Heavy Machining	
	Geometry	Grade	Geometry	Grade	Geometry	Grade
P1–P2	.E..ML	WP40PM	**.S..MM**	**WP40PM**	.S..MH	WP40PM
P3–P4	.E..ML	WP35CM	**.S..MM**	**WP35CM**	.S..MH	WP35CM
P5–P6	.E..ML	WP35CM	**.S..MM**	**WU35PM**	.S..MH	WP35CM
M1–M2	.E..ML	WP25PM	**.S..MM**	**WP25PM**	.S..MM	WU35PM
M3	.E..ML	WP35CM	**.S..MM**	**WP35CM**	.S..MH	WP35CM
K1–K2	.S..MM	WK15CM	**.S..MM**	**WK15CM**	.S..MH	WK15CM
K3	.E..ML	WP35CM	**.S..MM**	**WP35CM**	.S..MH	WP35CM
N1–N2	.F..ALP	WN10HM	**.F..ALP**	**WN25PM**	.F..ALP	WN25PM
N3	–	–	**–**	**–**	–	–
S1–S2	.S..MM	WP25PM	**.S..MM**	**WU35PM**	.S..MM	WU35PM
S3	.S..MM	WU35PM	**.S..MM**	**WU35PM**	.S..MM	WU35PM
S4	.S..MM	WP25PM	**.S..MM**	**WU35PM**	.S..MM	WU35PM
H1	–	–	**–**	**–**	–	–


XDCT-ML





● first choice
○ alternate choice

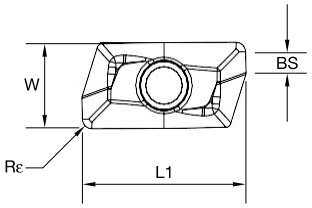
WIDIA VICTORY

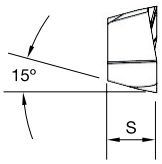
P				○	●	●	●
M				●	○	●	●
K	●			○	○		
N		●					
S				●		○	●
H				●	○		

XDCT-ML

catalogue number	cutting edges	L1	BS	S	W	Rε	WK15CM	WN25PM	WP25PM	WP35CM	WP40PM	WU35PM
XDCT170404PEERML	2	19,15	2,62	4,90	9,60	0,40	■	■	5989010	■	■	■
XDCT170408PEERML	2	19,15	2,22	4,90	9,60	0,80	■	■	5988983	5988982	5988981	■
XDCT170412PEERML	2	19,16	1,82	4,90	9,60	1,20	■	■	5988988	5988987	5988986	■
XDCT170416PEERML	2	19,17	1,42	4,90	9,60	1,60	■	■	6001257	■	■	■
XDCT170420PEERML	2	19,17	1,01	4,90	9,60	2,00	■	■	6001255	■	■	■
XDCT170424PEERML	2	19,17	0,63	4,90	9,60	2,40	■	■	6001253	■	■	■
XDCT170432PEERML	2	18,85	–	4,88	9,59	3,20	■	■	6001251	■	■	■
XDCT170440PEERML	2	18,33	–	4,87	9,59	4,00	■	■	6001239	■	■	■


XDCT-ALP





● first choice
○ alternate choice

P		
M		
K		
N	●	●
S		
H		

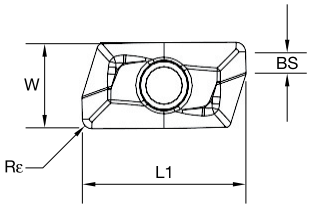
■ XDCT-ALP

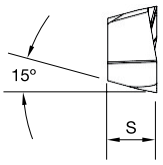
catalogue number	cutting edges	L1	BS	S	W	Rε	WN10HM	WN25PM
XDCT170404PEFRALP	2	19,15	2,62	4,90	9,60	0,40	6007341	6007220
XDCT170408PEFRALP	2	19,15	2,22	4,90	9,60	0,80	6007345	6007344
XDCT170412PEFRALP	2	19,16	1,82	4,90	9,60	1,20	6007342	6001537
XDCT170416PEFRALP	2	19,17	1,42	4,90	9,60	1,60	○	6001256
XDCT170420PEFRALP	2	19,17	1,01	4,90	9,60	2,00	○	6001254
XDCT170424PEFRALP	2	19,17	0,63	4,90	9,60	2,40	○	6001252
XDCT170432PEFRALP	2	18,85	–	4,88	9,59	3,20	○	6001240
XDCT170440PEFRALP	2	18,33	–	4,87	9,59	4,00	○	6001238

WIDIA VICTORY


XDPT-MM


XDPT-MH





● first choice
○ alternate choice

P				○	●	●	●
M				●	○	●	●
K	●			○	○		
N		●					
S				●		○	●
H				●	○		

XDPT-MM

catalogue number	cutting edges	L1	BS	S	W	Rε	WK15CM	WN25PM	WP25PM	WP35CM	WP40PM	WU35PM
XDPT170404PESRMM	2	19,15	2,52	4,90	9,60	0,40	-	-	-	-	5987689	5987690
XDPT170408PESRMM	2	19,15	2,15	4,90	9,60	0,80	5987948	-	5987949	5987947	5987946	5987950
XDPT170412PESRMM	2	19,16	1,77	4,90	9,60	1,20	5988138	-	5988151	5988140	5988139	5988152
XDPT170416PESRMM	2	19,17	1,38	4,90	9,60	1,60	5988153	-	5988155	5988156	5988154	-
XDPT170420PESRMM	2	19,17	0,99	4,90	9,60	2,00	-	-	5988158	5988160	5988159	-
XDPT170424PESRMM	2	19,17	0,62	4,90	9,60	2,40	-	-	5988203	-	5988202	-
XDPT170432PESRMM	2	18,85	–	4,89	9,59	3,20	-	-	5988206	5988204	5988205	-
XDPT170440PESRMM	2	18,33	–	4,87	9,59	4,00	-	-	5988970	-	5988969	-

XDPT-MH

catalogue number	cutting edges	L1	BS	S	W	Rε	WK15CM	WN25PM	WP25PM	WP35CM	WP40PM	WU35PM
XDPT170408PESRMH	2	19,15	2,10	4,91	9,60	0,80	5989053	-	-	5989054	5989052	-
XDPT170412PESRMH	2	19,16	1,73	4,91	9,60	1,20	5991817	-	-	5991816	5991815	-

Recommended Starting Speeds [m/min]

Material Group		WK15CM			WN25PM			WP25PM			WP35CM			WP40PM			WN10HM			WU35PM		
P	1	–	**–**	–	–	**–**	–	330	**285**	270	455	**395**	370	295	**260**	245	–	**–**	–	260	**230**	215
	2	–	**–**	–	–	**–**	–	275	**240**	200	280	**255**	230	250	**215**	180	–	**–**	–	220	**190**	160
	3	–	**–**	–	–	**–**	–	255	**215**	175	255	**230**	205	230	**195**	160	–	**–**	–	200	**170**	140
	4	–	**–**	–	–	**–**	–	225	**185**	150	190	**175**	160	205	**170**	135	–	**–**	–	180	**150**	120
	5	–	**–**	–	–	**–**	–	185	**170**	150	260	**230**	210	170	**155**	135	–	**–**	–	150	**135**	120
	6	–	**–**	–	–	**–**	–	165	**125**	100	160	**135**	110	150	**115**	90	–	**–**	–	130	**100**	80
M	1	–	**–**	–	–	**–**	–	205	**180**	165	205	**185**	155	195	**170**	155	–	**–**	–	170	**150**	135
	2	–	**–**	–	–	**–**	–	185	**160**	130	185	**160**	140	175	**150**	125	–	**–**	–	155	**130**	110
	3	–	**–**	–	–	**–**	–	140	**120**	95	145	**130**	115	130	**115**	90	–	**–**	–	115	**100**	80
K	1	420	**385**	340	–	**–**	–	230	**205**	185	295	**265**	240	–	**–**	–	190	**170**	150	–	**–**	–
	2	335	**295**	275	–	**–**	–	180	**160**	150	235	**210**	190	–	**–**	–	–	**–**	–	–	**–**	–
	3	280	**250**	230	–	**–**	–	150	**135**	120	195	**175**	160	–	**–**	–	–	**–**	–	–	**–**	–
N	1	–	**–**	–	1075	**945**	875	–	**–**	–	–	**–**	–	–	**–**	–	2000	**1200**	1000	–	**–**	–
	2	–	**–**	–	945	**875**	760	–	**–**	–	–	**–**	–	–	**–**	–	1365	**815**	665	–	**–**	–
	3	–	**–**	–	945	**875**	760	–	**–**	–	–	**–**	–	–	**–**	–	800	**500**	400	–	**–**	–
S	1	–	**–**	–	–	**–**	–	40	**35**	25	–	**–**	–	40	**35**	30	–	**–**	–	35	**30**	25
	2	–	**–**	–	–	**–**	–	40	**35**	25	–	**–**	–	40	**35**	30	–	**–**	–	35	**30**	25
	3	–	**–**	–	–	**–**	–	50	**40**	25	–	**–**	–	50	**40**	30	–	**–**	–	45	**35**	25
	4	–	**–**	–	–	**–**	–	70	**50**	35	66	**50**	33	65	**50**	35	–	**–**	–	60	**45**	30
H	1	–	**–**	–	–	**–**	–	120	**90**	70	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	2	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–
	3	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–	–	**–**	–

*NOTE: FIRST choice starting speeds are in **bold** type.*
As the average chip thickness increases, the speed should be decreased.

Recommended Starting Feeds

Recommended Starting Feeds [mm]

Light Machining	General Purpose	Heavy Machining

Insert Geometry	Programmed Feed per Tooth (fz) as a % of Radial Depth of Cut (ae)															Insert Geometry
	5%			10%			20%			30%			40–100%			
.F..ALP	0,12	**0,23**	0,58	0,08	**0,17**	0,42	0,06	**0,13**	0,31	0,06	**0,11**	0,27	0,05	**0,10**	0,25	.F..ALP
.E..ML	0,16	**0,35**	0,70	0,12	**0,25**	0,50	0,09	**0,19**	0,38	0,08	**0,16**	0,33	0,07	**0,15**	0,30	.E..ML
.S..MM	0,16	**0,46**	0,87	0,12	**0,33**	0,63	0,09	**0,25**	0,47	0,08	**0,22**	0,41	0,07	**0,20**	0,38	.S..MM
.S..MH	0,23	**0,58**	0,93	0,17	**0,42**	0,67	0,13	**0,31**	0,50	0,11	**0,27**	0,44	0,10	**0,25**	0,40	.S..MH

NOTE: Use "Light Machining" value as starting feed rate.

Victory™ Shoulder Mill 17™ Starter Kits

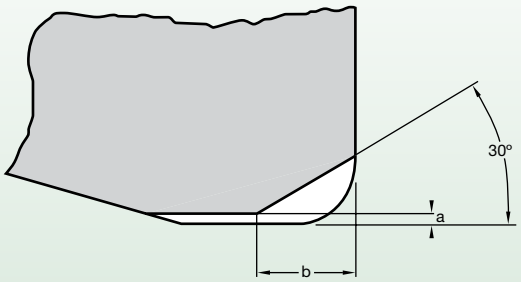
Order a VSM17 Kit to achieve true 90° high-performance shoulder milling!

Order one of our starter kits and test the performance of our new VSM17 platform. The kits are set up to serve the majority of shoulder milling applications, delivered with a cutter body and the latest WIDIA Victory™ grades. Detailed order information can be found in the table below.

VSM17 Starter Kits • Metric

order number	catalogue number	diameter D1 (mm)	cutter body type	material group	content					
					cutter	qty	inserts	qty	grade	Z (Pocket Seats)
6049187	VSM17KITCD025Z2WP40PM	25	CYLINDRICAL	P	VSM17D025Z02A25XD17L110	1	XDPT170408PESRMM	10	WP40PM	2
6049185	VSM17KITSW025Z2WP40PM	25	SCREW ON	P	VSM17D025Z02M12XD17	1	XDPT170408PESRMM	10	WP40PM	2
6049186	VSM17KITWD025Z2WP40PM	25	CYLINDRICAL	P	VSM17D025Z02B25XD17	1	XDPT170408PESRMM	10	WP40PM	2
6049190	VSM17KITCD032Z3WP40PM	32	CYLINDRICAL	P	VSM17D032Z03A32XD17L120	1	XDPT170408PESRMM	10	WP40PM	3
6049188	VSM17KITSW032Z3WP40PM	32	SCREW ON	P	VSM17D032Z03M16XD17	1	XDPT170408PESRMM	10	WP40PM	3
6049189	VSM17KITWD032Z3WP40PM	32	WELDON	P	VSM17D032Z03B32XD17	1	XDPT170408PESRMM	10	WP40PM	3
6049311	VSM17KITCD032Z2WP40PM	32	WELDON	P	VSM17D032Z02A32XD17L120	1	XDPT170408PESRMM	10	WP40PM	2
6049313	VSM17KITCD040Z4WP40PM	40	CYLINDRICAL	P	VSM17D040Z04A32XD17L130	1	XDPT170408PESRMM	10	WP40PM	4
6049312	VSM17KITSD040Z4WP40PM	40	SHELL MILL	P	VSM17D040Z04S16XD17	1	XDPT170408PESRMM	10	WP40PM	4
6049314	VSM17KITSD050Z4WP40PM	50	SHELL MILL	P	VSM17D050Z04S22XD17	1	XDPT170408PESRMM	10	WP40PM	4
6049315	VSM17KITSD050Z5WP40PM	50	SHELL MILL	P	VSM17D050Z05S22XD17	1	XDPT170408PESRMM	10	WP40PM	5
6049316	VSM17KITSD063Z5WP40PM	63	SHELL MILL	P	VSM17D063Z05S22XD17	1	XDPT170408PESRMM	10	WP40PM	5
6049317	VSM17KITSD080Z6WP40PM	80	SHELL MILL	P	VSM17D080Z06S27XD17	1	XDPT170408PESRMM	10	WP40PM	6
6049318	VSM17KITSD100Z8WP40PM	100	SHELL MILL	P	VSM17D100Z08S32XD17	1	XDPT170408PESRMM	10	WP40PM	8
6049321	VSM17KITCD025Z2WK15CM	25	CYLINDRICAL	K	VSM17D025Z02A25XD17L110	1	XDPT170408PESRMM	10	WK15CM	2
6049319	VSM17KITSW025Z2WK15CM	25	SCREW ON	K	VSM17D025Z02M12XD17	1	XDPT170408PESRMM	10	WK15CM	2
6049320	VSM17KITWD025Z2WK15CM	25	CYLINDRICAL	K	VSM17D025Z02B25XD17	1	XDPT170408PESRMM	10	WK15CM	2
6049324	VSM17KITCD032Z3WK15CM	32	CYLINDRICAL	K	VSM17D032Z03A32XD17L120	1	XDPT170408PESRMM	10	WK15CM	3
6049322	VSM17KITSW032Z3WK15CM	32	SCREW ON	K	VSM17D032Z03M16XD17	1	XDPT170408PESRMM	10	WK15CM	3
6049323	VSM17KITWD032Z3WK15CM	32	WELDON	K	VSM17D032Z03B32XD17	1	XDPT170408PESRMM	10	WK15CM	3
6049325	VSM17KITCD032Z2WK15CM	32	WELDON	K	VSM17D032Z02A32XD17L120	1	XDPT170408PESRMM	10	WK15CM	2
6049327	VSM17KITCD040Z4WK15CM	40	CYLINDRICAL	K	VSM17D040Z04A32XD17L130	1	XDPT170408PESRMM	10	WK15CM	4
6049326	VSM17KITSD040Z4WK15CM	40	SHELL MILL	K	VSM17D040Z04S16XD17	1	XDPT170408PESRMM	10	WK15CM	4
6049328	VSM17KITSD050Z4WK15CM	50	SHELL MILL	K	VSM17D050Z04S22XD17	1	XDPT170408PESRMM	10	WK15CM	4
6049329	VSM17KITSD050Z5WK15CM	50	SHELL MILL	K	VSM17D050Z05S22XD17	1	XDPT170408PESRMM	10	WK15CM	5
6049330	VSM17KITSD063Z5WK15CM	63	SHELL MILL	K	VSM17D063Z05S22XD17	1	XDPT170408PESRMM	10	WK15CM	5
6049331	VSM17KITSD080Z6WK15CM	80	SHELL MILL	K	VSM17D080Z06S27XD17	1	XDPT170408PESRMM	10	WK15CM	6
6049332	VSM17KITSD100Z8WK15CM	100	SHELL MILL	K	VSM17D100Z08S32XD17	1	XDPT170408PESRMM	10	WK15CM	8

Modification Instructions for Use of Larger Radii Inserts (Shoulder Mills and Helical Mills)



	material to remove	
insert corner radius	**a**	**b**
3,1mm	0,2mm	1,8mm

Victory™ Shoulder Mill 17™
ADVANCES 2017

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